Work Order February-12-14 11			*119	3316*						Page 1
Revision ID:	566-1 B113 D355 sket Fwd & Aft	9 1 6 9 - 1	Accept	*N90	0040	100) * ፡	Setup Sta	17	S1* S2*
Start Date: 2/1 Required Date: 2/1 Reference:	2/14 Start Qty: 16.00 2/14 Req'd Qty: 16.00			Cust Ite Custom						,
	rocess Plan: MUS	Date: 14-02-1			Date:		F	Run Sta Sto	^ \	R1* R2*
Sequence ID/ Work Center ID	Operation Description	-	Set Up/ Run Hours	Tool I	D Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr									
D3566	Rev C									
*100 *100* Waterjet FLOW CNC Waterjet	FLOW WATER JET Memo 1-Cut as p Deburr if	per Dwg D3566 Dwg Rev:_ necessary	0.00 0.00 Prog Rev:	 2-			16	0		Jm 14.02-20
110 *110* QC Quality Control	QC2- Inspect parts off Memo	machine FAI/FAIB	0.00				16	_0	_	Jm14-02-20
120 *1 <i>2</i> 0* QC	QC8- Inspect parts - se Memo	econd check	2	27 27 39 30			16			

Quality Control

DQA:			Date:			~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~							
QA Closed:			Date:			WORK ORDER NON	-CC	ONFOI	RMANCE / L		Vork Order uj	odate only	AEROSPACE
Work Orde	· ·		-			DISPOSITION					EPARTMENT	·	- 1
Work Orde	–					Danie de la constante de la co	,				\neg	\4(a4a = 1a4	7
Part N	lo					Rework Scrap		l .	Skid-tube Machining	Crosstube Small Fab		Water Jet d. Eng. Coor.	Engineering Quality
NCR N	lo					Use-as-is Suspected Unapproved		Thern	noforming Large Fab	Finishing _ Composite _	Rec/Sto	Other	
Root					Desc	ription of work order update	ĺ	nitial	Ac	ction	Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Desc	cription	Date	Verification	QC Inspector
Design													
Doc/Data													
Equip/Tooling													
Handling/Pre													
Material													
Operator	\Box						1						
Offset/Setup													
Process													
Supplier	\neg												•
Training	\neg			·	Ì								
Transport													
Unapproved	\neg												
· · · · · · · · · · · · · · · · · · ·					1		FAI	ULT CAT	TEGORY			1	
Landir	ng G	ear			<u>'</u>	General							
	$\overline{}$	Bending				Bend		Folio/P	rogram	Γ	Outside Dim	ensions	Pressure/Forced
Ì	-	Centre No	ot Concer	ntric		BOM/Route		Grain	J		Over/Under	—	Set-up
	-	Cracks				Broken/Damage/Defect		Hardwa	ire	<u> </u>	Part Incorre	├	Temperature/Cure
	—	Crimp/Kir	nk/Ripple	/Wave		Burrs		4	ion Incomplete/L	Jngualified	Part Lost/M		Weld
ľ	_	Cuffs			_	Contamination	_	1	ions Incomplete	<u> </u>	Part Moved	_	Wrong Stock Pulled
ļ	_	Crushing				Countersink	\vdash	-	ned/off center		Positioned V		
	-	Heat Trea	t			Cut Too Short	\vdash	Mislabe		<u> </u>	Power Loss/	_	Other
		nspection		Tube		Drawing		Misread					1
	-	Marks/Ch	•			Drill Holes	—	Off-set					·
		Turning S				Finish	\vdash	4	Calibration				W
 	_	Wave/Tw	•		<u> </u>	Fit/Function	H	4	Seguence			J. 1977 1070 - 1	

Work Orde February-12-14				*113			Page 2					
Revision ID:	D3566-1 Gasket Fwd	& Aft		Accept	*N900	04 0	100	n *	Setup	Start Stop		S1* S2*
Start Date: Required Date: Reference:	2/12/14 2/12/14	Start Qty: 16.00 Req'd Qty: 16.00	*16* *16*		Cust Item 1 Customer:	D:						
Approvals:	Process Pl QC:	lan:	Date:	Tooling: SPC (Y/N):		ate:			Run	Start Stop	*N	R1* R2*
Sequence ID/ Work Center ID	•	Operation Description Identify as per dwg & Sto	ck Location: \\\^2-60\	Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accep Qty	t Re Qt		Reject Number	Insp. Stamp
120 Packaging		Мето	·	0.00				X16		<u>(</u>		102/2

0.00

0.00

QC21- Final Inspection - Work Order Release

Memo

140

140

Quality Control

#-02-21

DQA:		Date:						_				TRACT
QA Closed:		Date:			WORK ORDER NON-	-CC	ONFO	RMANCE / UP		Vork Order uj	odate only	AEROSPACE
					DISPOSITION					EPARTMENT	·····	
Work Orde	r:								_			
					Rework		Skid-tube Crosstube			_	Water Jet	Engineering
Part N	o				Scrap			Machining	Small Fab	_	d. Eng. Coor.	Quality
NCR N	0				Use-as-is Suspected Unapproved		Thern	noforming Large Fab	Finishing Composite	Rec/Sto	re/Packaging Supplier	Other
WCK IV	·				Suspected Ollappioved	ا ا		raige rab	Composite		J LJ	
Root		<u> </u>	i	Desci	iption of work order update		nitial	Actio	on	Sign &		
Cause	Date	Step	Qty		or non-conformance	Ch	ief Eng	Descrip	otion	Date	Verification	QC Inspector
Design												
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quip/Tooling												
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Material				,								
Operator												
Offset/Setup		1										
rocess										İ		
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Training												
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						FAI	ULT CA	TEGORY				
Landin	g Gear				General		-		-			-
	Bending				Bend		Folio/F	Program	L	Outside Dim	ensions	Pressure/Forced
	Centre No	ot Concei	ntric		BOM/Route		Grain		L	Over/Under	tolerance	Set-up
	Cracks				Broken/Damage/Defect	L	Hardwa	are		Part Incorre	cí _	Temperature/Cure
	Crimp/Kir	nk/Ripple	:/Wave		Burrs		Inspect	ion Incomplete/Unq	ualified	Part Lost/Mi	issing	Weld
	Cuffs				Contamination		4	tions Incomplete/Un	nclear	Part Moved		Wrong Stock Pulled
	Crushing				Countersink	<u>_</u>		gned/off center		Positioned V		_
	Heat Trea				Cut Too Short	L	Mislabe	eled	L	Power Loss/	Surge	Other
Ĺ	Inspectio	n Strip in	Tube		Drawing		Misread	d				
L	Marks/Ch	natter			Drill Holes		Off-set		•		·	
	Turning S	-			Finish		Out of	Calibration				· · · · · · · · · · · · · · · · · · ·
	Wave/Twist in Tube			Fit/Function	1	lout of	Saguanca					

February-12-14 9:54:16 AM

Work Order ID:

113316

Parent Item:

D3566-1

Parent Item Name:

Gasket Fwd & Aft

Start Date: 2/12/14

Required Date: 2/12/14

Start Qty: 16.00

Required Qty: 16.00

Comments:

IPP Rev:A

New Issue 07-03-08 ec

IPP Rev:B

Added Drain Holes 07-07-09 JLM

IPP Rev:C As per Rev C 07-09-09 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MNEO60S.063		Purchased	No		14.75	100	sf	27.1000	0.911	16.19555	5		
NEOPRENE SHEET 0.06	i3	Turchased				100		27.12000	0.711	111111111111111111111111111111111111111	'ι ٦ .		Jm1840

Location	Loc Qty	Loc Code	
MAT052	27.1		
M126546	27.1		

128266

128266

DQA:			Date:				\sim						
						WORK ORDER NON-	-CC	ONFO	RMANCE / UF	PDATE			AEROSPACE
QA Closed:			Date:							V	/ork Order u	pdate only]
Work Orde	er:					DISPOSITION		,		AGAINST D	EPARTMENT	/PROCESS	
				,	_	Rework			Skid-tube	Crosstube	1 .	Water Jet	Engineering
Part N	lo.					Scrap		Machining Small Fab			Pro	od. Eng. Coor.	Quality
,						Use-as-is	ĺ	Thern	noforming	Finishing	_	re/Packaging	Other
NCR N	lo					Suspected Unapproved			Large Fab	Composite		Supplier	
Root					Descr	cription of work order update		nitial	Acti	on	Sign &		
Cause		ate	Step	Qty		or non-conformance	Ch	ief Eng	Descri	ption	Date	Verification	QC Inspector
Design		į							·				
Doc/Data													
Equip/Tooling						•							
Handling/Pre									1				
Material	_	İ											
Operator	_						ļ						
Offset/Setup	_										İ		
Process	_					-	ĺ						
Supplier	_												
Training								-					
Transport													
Unapproved							-		L				
							FAI	ULT CA	TEGORY				
Landir	ng Gear					General		1		_	٦	·	7_ /
	—	nding				Bend	-	1	Program	· -	Outside Din		Pressure/Forced
	—		t Concer	ntric		BOM/Route	\vdash	Grain	-	·	Over/Under	<u>}</u>	Set-up
		icks	. /n:		-	Broken/Damage/Defect		Hardwa		-	Part Incorre	 	Temperature/Cure
i		•	k/Ripple	/Wave	-	Burrs	-	1	ion Incomplete/Un	· —	Part Lost/M		Weld
	Cut				-	Contamination	\vdash	1	tions Incomplete/U	nclear	Part Moved	<u> </u>	Wrong Stock Pulled
	_	shing			-	Countersink	\vdash	•	gned/off center	-	Positioned		Joshan
		at Treat		Tula -	\vdash	Cut Too Short	-	Mislabe		L.	Power Loss,	'Surge	Other
-	_	-	Strip in	rupe	-	Drawing	\vdash	Misrea				<u>.</u>	
	_	rks/Ch			-	Drill Holes	\vdash	Off-set					
	\vdash		equence		-	Finish	\vdash	4	Calibration	•	-		
	Wave/Twist in Tube Fit/Function				Fit/Function		Out of	Sequence					

DART AEROSPACE LTD	Work Order:	113316
Description: Gasket	Part Number:	D3566-1
Inspection Dwg: D3566 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.10	+/-0.030	310"			U	Jemoi
18.00	+/-0.030	18.00	-		T	Jamolo
12.10	+/-0.030	12.10"	-		丁	
2.43	+/-0.030	243"	_		V	
6.00	+/-0.030	(e 00~	_		U	
1.40	+/-0.030	1.40"	-		7	
0.30	+/-0.030	0.30"	-		V	
0.30	+/-0.030	0.30"	_		V	
0.063	+/-0.010	0.060	-		V	
Ø0.188	+0.005/-0.001	0.190"	_		V	
					- 11	
_						

Measured by:
Jm

Date:
14-02-10

Audited by:

9-89
Prototype Approval:

N/A

Date:
N/A

Rev	Date	Change	Revised by	Approved
Α	07.03.14	New Issue	KJ/JLM	
В	07.07.18	Dimensions updated per Dwg Rev. B	KJ/JLM , a	
С	07.09.26	Dwg Rev updated	KJ/EC/DD	E
			()	

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